

Work Order ID 108280

October-10-13 1:39:49 PM

108280

Page 1

Item ID: D2896-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support
 Start Date: 10/10/13 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 10/24/13 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 13-10-10 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2896	C

100

0.00

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio FA167

Folio Rev: AA

Dwg Rev: C

0.00

Deburr

****Program Batch #*****

DAS
02
89 13-10-28

110

0.00

110

QC

Quality Control

QC1- Inspect dimensions to dimension sheet

Memo

0.00

DAS
02
89 13-10-28

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Page 2

Item ID: D2896-1 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Support
 Start Date: 10/10/13 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 10/24/13 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>L683</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

cmk 13/11/06

20 0

20 0 0 13-11-7

10/11/07 13/11/07

ME 13-11-07

Picklist Print

October-10-13 1:39:53 PM

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Work Order ID: 108280

108280

Parent Item: D2896-1

D2896-1

Parent Item Name: Support

Start Date: 10/10/13

Required Date: 10/24/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: B02.11.26Reformat; Added P/O; Added mask holeKJ
 IPP Rev:C As per Rev B 07-04-16 JLM
 IPP D 08.03.19 Re-format EC verified by DD IPP REV:E
 11.10.03 ASPER REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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DSK080		Manufactured	No			100	Each	31.0000	0.5	10			
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DSK080

D2896-1 Turning Detail

**

10/10/13 13:10:23

Location	Loc Qty	Loc Code
MAT060	31	
103895	8	
104458	20	
89143	1	
89632	2	

~~10~~ x 7
 x 1
 x 2

DART AEROSPACE LTD		Work Order:	108280
Description: Support		Part Number:	D2896-1
Inspection Dwg: D2896	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.152	2.172		2.172	2.172	2.162	2.170	2.165
AB	2.340	2.360		2.360	2.360	2.351	2.352	2.353
AC	3.550	3.560		3.556	3.554	3.558	3.557	3.556
AD	3.770	3.790		3.779	3.779	3.777	3.776	3.772
AE	0.065 x 0.315	0.085 x 0.335		0.078 x .337	0.0780 x .337	0.078 x .337	0.078 x .337	0.078 x .337
AF	1.42	1.48		1.460	1.460	1.460	1.460	1.460
AG	0.833	0.853		.837	.849	.836	.833	.834
AH	0.240	0.260		.250	.250	.250	.250	.250
AI	0.261	0.266		.263	.263	.263	.263	.263
AJ	0.189	0.194		.192	.192	.192	.192	.192
AK	1.970	2.030		2.001	2.000	2.000	2.000	1.997
AL	0.625	0.630		.626	.626	.626	.626	.626
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.926	0.946		.946	.946	.945	.944	.942
AP								
AQ								
AR								
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"								
Accept/Reject				.002	.003	.0015	.0015	0.0000

Measured by: <i>[Signature]</i>	Date: 13-10-28
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Audited by: <i>[Signature]</i>	Date: 13/11/06
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	108280
Description: Support		Part Number:	D2896-1
Inspection Dwg: D2896		Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6X	7X	8X	9X	10X
HAAS Section								
AA	2.152	2.172		2.167	2.169	2.172	2.172	2.170
AB	2.340	2.360		2.353	2.349	2.354	2.351	2.355
AC	3.550	3.560		3.555	3.555	3.555	3.557	3.555
AD	3.770	3.790		3.771	3.767	3.786	3.7845	3.782
AE	0.065 x 0.315	0.085 x 0.335		.078 x .333	.078 x .333	.078 x .333	.078 x .333	.078 x .333
AF	1.42	1.48		1.460	1.460	1.460	1.460	1.460
AG	0.833	0.853		.834	.839	.839	.848	.849
AH	0.240	0.260		.250	.250	.250	.250	.250
AI	0.261	0.266		.263	.263	.263	.263	.263
AJ	0.189	0.194		.192	.192	.192	.192	.192
AK	1.970	2.030		2.001	1.999	2.000	1.9995	1.9975
AL	0.625	0.630		.626	.627	.626	.626	.6265
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.926	0.946		.944	.939	.940	.9425	.942
AP								
AQ								
AR								

Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"

Accept/Reject .002 .0025 .002 .0005 .002

Measured by: *DR1*

Date: 13-10-28

Audited by: *[Signature]*

Date: 13-10-29

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
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C	06.11.22	Note added to HAAS section	KJ/JLM	
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DART AEROSPACE LTD		Work Order:	108280
Description: Support		Part Number:	D2896-1
Inspection Dwg: D2896		Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
HAAS Section								
AA	2.152	2.172		2.170	2.171	2.170	2.172	2.165
AB	2.340	2.360		2.356	2.355	2.354	2.356	2.356
AC	3.550	3.560		3.558	3.556	3.557	3.555	3.553
AD	3.770	3.790		3.790	3.788	3.786	3.789	3.784
AE	0.065 x 0.315	0.085 x 0.335		.072.333	.078.333	.078.334	.077.333	.077.333
AF	1.42	1.48		1.460	1.460	1.460	1.460	1.460
AG	0.833	0.853		.841	.847	.841	.835	.834
AH	0.240	0.260		.250	.250	.250	.250	.250
AI	0.261	0.266		.263	.263	.263	.263	.263
AJ	0.189	0.194		.192	.192	.192	.192	.192
AK	1.970	2.030		1.9955	1.995	2.0015	2.004	2.002
AL	0.625	0.630		.626	.626	.626	.626	.626
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.926	0.946		.940	.945	.941	.945	.944
AP								
AQ								
AR								
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"								
Accept/Reject				.0025	.0010	.0000	.0005	.0003

Measured by: DR. BT DA 0.02	Date: 13/10/29
Audited by: [Signature]	Date: 13/11/06
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
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DART AEROSPACE LTD		Work Order:	108280
Description: Support		Part Number:	D2896-1
Inspection Dwg: D2896		Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	2.152	2.172		2.170	2.172	2.161	2.166	2.167
AB	2.340	2.360		2.353	2.360	2.352	2.356	2.355
AC	3.550	3.560		3.556	3.555	3.557	3.555	3.556
AD	3.770	3.790		3.787	3.790	3.790	3.780	3.780
AE	0.065 x 0.315	0.085 x 0.335		0.077 x 0.333	0.077 x 0.333	0.077 x 0.333	0.077 x 0.333	0.077 x 0.333
AF	1.42	1.48		1.460	1.460	1.460	1.460	1.460
AG	0.833	0.853		0.833	0.834	0.833	0.833	0.834
AH	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AI	0.261	0.266		0.263	0.263	0.263	0.263	0.263
AJ	0.189	0.194		0.192	0.192	0.192	0.192	0.192
AK	1.970	2.030		1.984	2.020	2.000	2.007	2.003
AL	0.625	0.630		0.626	0.626	0.626	0.626	0.626
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75
AN	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AO	0.926	0.946		0.943	0.945	0.945	0.945	0.944
AP								
AQ								
AR								

Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"

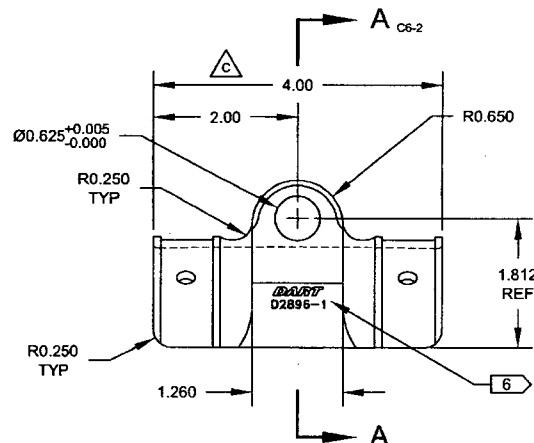
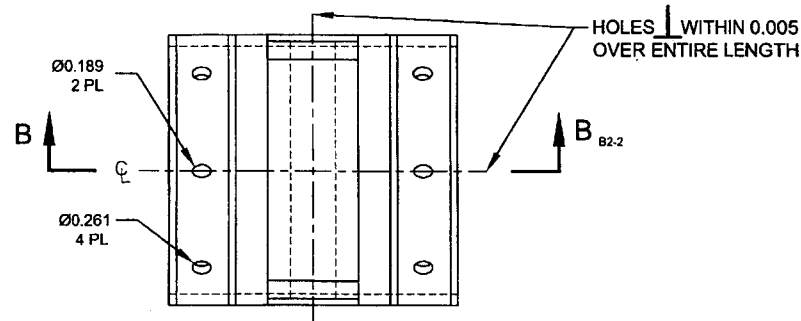
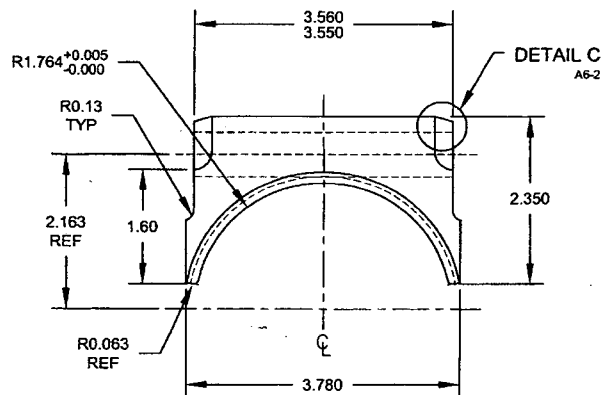
Accept/Reject 0.002 0.0015 0.0005 0.001 0.004

Measured by: *[Signature]* Date: 13/11/01

Audited by: *[Signature]* Date: 13/11/06

Preliminary Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
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C	06.11.22	Note added to HAAS section	KJ/JLM	
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E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	<i>[Signature]</i>

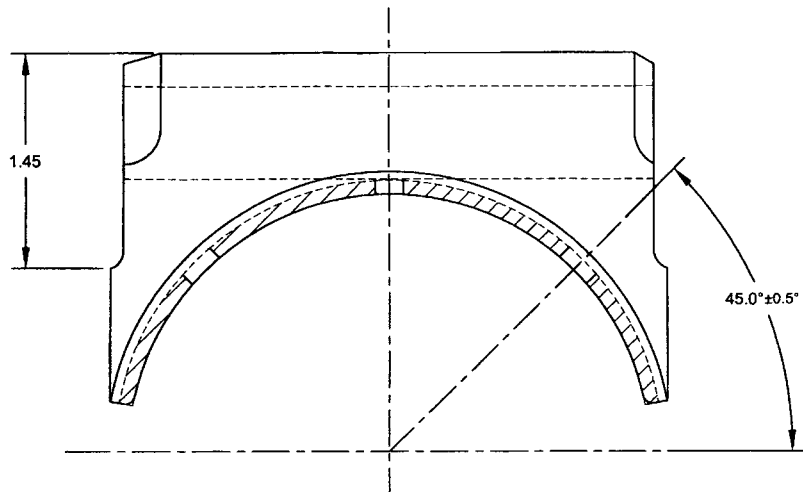


D2896-1 SUPPORT

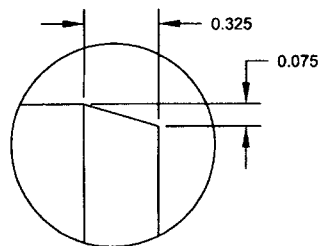
NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
PER ASTM A564 OR AMS 5643 OR AISI 630
MIN UTS = 170 KSI (38 HRC)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO AND P/N WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP PER DART QSI 044 6.3
- 7) WEIGHT: 1.76 lbs

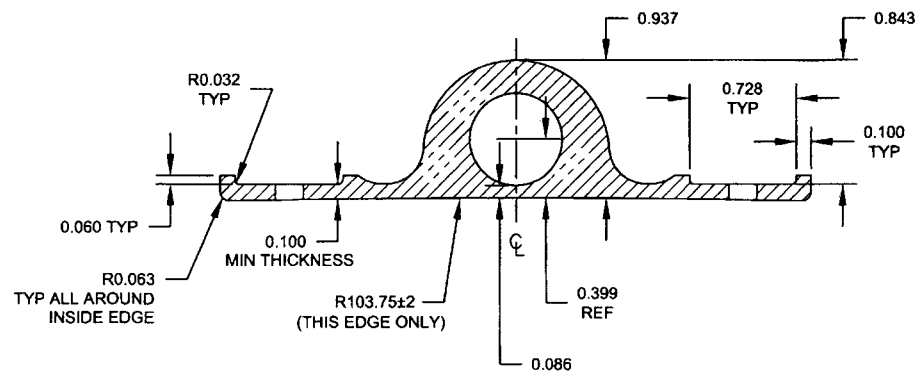
C	RMV FINISH & UPDATE MAT'L SPEC (A8-1), 2.00 WAS 2.000, 4.00 WAS 4.000 (C4-1), REFORMAT DWG	CP	11.09.07
B	INCCORP. A1-A4, FINISHING NOTES	PH	07.03.19
A	NEW ISSUE	CP	01.10.19
DESIGN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	JP	D2896	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	SUPPORT	NTS
DATE	11.09.07	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION A-A C3-1
TOOLING HOLE DETAIL
SCALE 2X



DETAIL C C6-1
SCALE 4X



SECTION B-B D3-1
SCALE 2X

RELEASED
2011-09-29

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2896	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT	NTS
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